

Date: Thursday, 2/14/2008 10:56:35 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 37424	
Estimate Number : 10940	
P.O. Number :	Part Number : D29381
This Issue : 2/14/2008 S.O. No. :	Drawing Number : D2938 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34631	Material :
Written By :	Due Date : 3/8/2008 Qty: 10 Um: Each
Checked & Approved By : <u>080214</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B34873

2F 08/04/06

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

2F 08/04/06

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

2F 08/04/06

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

2F 08/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:56:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 37424

Part Number: D29381

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/04/07

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/04/08 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

FL 08-04-08 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/04/08 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 42a

AS 08/04/08 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



MF 08-04-08

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 37424
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.131	.131	.127	.128		
B	0.100	0.140		.134	.130	.128	.130		
C	0.100	0.140		.122	.121	.117	.117		
D	0.210	0.230		.217	.218	.219	.220		
E	1.245	1.255		1.248	1.248	1.248	1.248		
F	1.245	1.255		1.248	1.248	1.248	1.248		
G	2.495	2.505		2.499	2.500	2.499	2.500		
H	0.510	0.515		.511	.511	.510	.510		
I	1.572	1.582		1.577	1.577	1.579	1.579		
J	2.495	2.505		2.500	2.500	2.501	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.118	.117	.118	.119		
O	0.540	0.560		.545	.555	.553	.555		
P	0.490	0.510		.504	.510	.502	.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.741	2.741	2.743	2.742		
S	0.240	0.270		.252	.248	.250	.248		
T	0.100	0.180		.133	.128	.146	.140		
U	1.625	1.635		1.630	1.630	1.632	1.630		
V	1.362	1.372		1.370	1.370	1.369	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.260	1.260	1.261		
Y	1.565	1.585		1.569	1.570	1.570	1.568		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: 08/04/06

Audited by: <i>J.L.</i>
Date: 08/04/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>RF</i>	<i>RF</i>

DART AEROSPACE LTD	Work Order: 37424
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	54	63	73	84		
A	0.100	0.140		.128	.128	.128	.127		
B	0.100	0.140		.129	.129	.129	.126		
C	0.100	0.140		.121	.121	.121	.119		
D	0.210	0.230		.220	.218	.224	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.501	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.238	.237		
N	0.100	0.140		.117	.118	.118	.118		
O	0.540	0.560		.550	.550	.554	.556		
P	0.490	0.510		.505	.505	.503	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.743	2.743	2.743	2.743		
S	0.240	0.270		.248	.248	.250	.246		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.633	1.633	1.633	1.633		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.260	1.260	1.261		
Y	1.565	1.585		1.570	1.570	1.570	1.569		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: <i>08/03/06</i>

Audited by: <i>JL</i>
Date: <i>08/04/07</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 37424
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

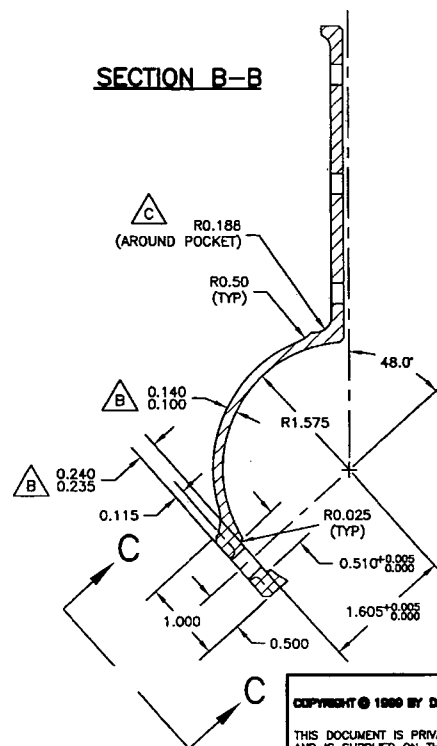
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9x	10x	3	4	By	Date
A	0.100	0.140		.128	.128				
B	0.100	0.140		.129	.129				
C	0.100	0.140		.121	.121				
D	0.210	0.230		.221	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.501	2.501				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.316	.316				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.117	.117				
O	0.540	0.560		.555	.550				
P	0.490	0.510		.501	.508				
Q	3.715	3.725		3.718	3.714				
R	2.720	2.760		2.743	2.743				
S	0.240	0.270		.246	.246				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.633	1.633				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.321	.321				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585		1.569	1.569				
Z	0.178	0.198		.184	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>L.F.</i>
Date: 08/04/07


Audited by: <i>J.L.</i>
Date: 08/04/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.25	
B	00.05.29	CHANGED GEOMETRY AND MATERIAL	
A	99.11.12	NEW ISSUE	
DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED		
DATE		DRAWING NO.	REV. C
06.11.09		D2938	SHEET 1 OF 1
		TITLE	SCALE
		SADDLE OUTSIDE	2:3

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NO. 37424

52,500

07.02.12